

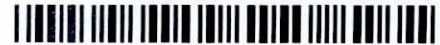


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4202-1

Job Sheet 179030



Part No: D4202-1

Job Qty: 500 Ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/12/18

Job Tracking No:

Due Date: 6/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM
VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	500 Ea	6/28/18	6/28/18	0.00	0.00	Start Up Machining-2		JB 18-06-22
100	Hardinge	500 pcs	6/28/18	6/28/18	0.00	21.28	Hardinge		JB 18-06-22
120	QC	500 pcs	6/28/18	6/28/18	0.00	0.00	QC8		A.P. 18-06-22
130	Outsource	500 pcs	6/28/18	6/28/18			ME1001-VG ATLANTIC		CT 18-06-25
140	Packaging	500 pcs	6/28/18	6/28/18	0.00	0.00	Packaging2		JUL 17 2018
150	QC	500 pcs	6/28/18	6/28/18	0.00	0.00	QC6		JUL 17 2018 38
160	HandFinish	500 pcs	6/28/18	6/28/18	0.00	2.50	HandFinish4		9-89
190	Packaging	500 pcs	6/28/18	6/28/18	0.00	0.00	Packaging3-2		
200	QC21-SA	500 Ea	6/28/18	6/28/18	0.00	0.00	QC21		

Part Op 100 - 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***

Descriptions: 130 - ***HEAT TREAT AS PER DWG D4202***

160 - WASH SPACER AS PER QSI005

190 - ***STOCK IN SKIDTUBE CELL***

DAS
21
9-20

JUL 20 2018

Metzor: PO: P0040411

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	175 ft (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.058	175	404	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches ± 0.010	0.510 0.490	Product	
2	Spacer	0.058inches ± 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

4.55

Plex 6/20/18 11:37 AM Dart.lajeunesse.marie

A:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date :				MRB (QSI042) Approval	
Description				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Date: 06/22/18			
Container No: S083226 Part: D4202-1 Job No: 179030 Serial No/Batch: S083226		Revision: Inspector: Exp Date: Instructions:			
Root Cause Environment ☐ No Re-verfic ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setu ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	
				Surge ☐ Positioned Wrong ☐ m ☐ Outside Dimensions ☐ ☐ Over/Under tolerance ☐ ☐ Part Incorrect ☐ ☐ Part Lost/Missing ☐ ☐ Part Moved ☐ ☐ Drawing ☐ ☐ Finish ☐ ☐ Misread ☐ ☐ Turning Sequence ☐	
		OTHER :			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040411

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO040411
PO Date: 7/5/18
Due Date: 7/13/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179030	D4202-1	Spacer ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6 ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6 ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6 ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6	Firmed	-	7/13/18	512 pcs	0 pcs	512 pcs	\$1.30371094/pcs	\$667.50

Grand Total: \$667.50

Order Notes

CC

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
328937	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40411	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCT	36 - 44 %IACS		103 (60 khz)	40 - 42 %IACS
HARDNESS	60 HREW MIN		103	64 - 67 HREW MESURE EN HR15TW = 64,5-66,3 HR15TW
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
512	17	D4202-1 (512) D4202-1 JOB # 179030 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 30 MIN
AGE HARDEN AMBIANT 96 HRS

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été fait par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Isabel Otero
QA Technician

METCOR
12

13 JUL 2018

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
328937	1	129581

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
40411		AL-6061	2018/7/9	FED GROUND

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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512 D4202-1
(512) D4202-1
JOB # 179030
17,

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
-------------------------------------	------------------------------------	--

BOITE DE CARTON 1

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 512

POIDS EXPÉDIÉ / Weight Shipped : 17,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVE

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 512

POIDS EXPÉDIÉ / Weight Shipped : 17,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
328937	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40411	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	103	40 - 42 %IACS
HARDNESS	60 HREW MIN	103	64 - 67 HREW
MESURE EN HR15TW = 64,5-66,3 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
512	17	D4202-1 (512) D4202-1 1 BOITE DE CARTON

19/7/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-07-13

APPROUVÉ